

# Work Order ID 81809

**\*81809\***

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March-19-12 1:35:55 PM

Item ID: D2651-1

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Stop

**\*NS2\***

Item Name: Plug

Start Date: 19/03/2012 Start Qty: 120.00

**\*120\***

Cust Item ID:

Required Date: 18/05/2012 Req'd Qty: 120.00

**\*120\***

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 12/03/15

Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2651

Rev B

100

0.00

**\*100\***

Hardinge CNC LATHE SMALL

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

1- Turn as per Folio FA219 and Dwg D26512- Deburr

*SL 12/4/13*

110

QC2- Inspect parts off machine FAI/FAIB

0.00

**\*110\***

QC

Memo

0.00

Quality Control

*SL 12/4/13*

120

QC8- Inspect parts - second check

0.00

**\*120\***

QC

Memo

0.00

Quality Control

*120 / 120 / 120*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Work Order ID 81809

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Item ID: D2651-1

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Plug

Start Date: 19/03/2012 Start Qty: 120.00

**\*120\***

Cust Item ID:

Required Date: 18/05/2012 Req'd Qty: 120.00

**\*120\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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140

Chemical Conversion Coat per QSI005 4.1

0.00

**\*140\***

HandFinish

Memo

0.00

Hand Finishing

120XQ M/L 12/04/04

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

**\*150\***

Powdercoat

Memo

0.00

Powder Coating

(Only larger section necessary) START TIME: 3h45  
TIME: 4h15 OVEN TEMPERATURE: 320°F FINISH

M120222

120 X Q (SP) 12/04/04

160

QC3- Inspect Part Finish

0.00

**\*160\***

QC

Memo

0.00

Quality Control

120XQ M/L 12/04/05

**Dart Aerospace Ltd**

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**\*81809\***

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March-19-12 1:35:55 PM

Item ID: D2651-1

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Plug

Start Date: 19/03/2012 Start Qty: 120.00

**\*120\***

Cust Item ID:

Required Date: 18/05/2012 Req'd Qty: 120.00

**\*120\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

170

Identify as per dwg & Stock Location:

*FPA*

0.00

**\*170\***

Packaging

Memo

0.00

Packaging

*120x4 M / 12/04/15*

180

QC21- Final Inspection - Work Order Release

0.00

**\*180\***

QC

Memo

0.00

Quality Control

*12/4/5*

*12-04-5*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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**NOTE:** Date & initial all entries

# Picklist Print

March-19-12 1:36:00 PM

Page 1

Work Order ID: 81809

\*81809\*

Parent Item: D2651-1

\*D2651-1\*

Parent Item Name: Plug

Start Date: 19/03/2012

Required Date: 18/05/2012

Start Qty: 120.00

Required Qty: 120.00

Comments: IPP: A02.04.15New Issue NG  
IPP: B05.12.12added deburr EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6R0.500		Purchased	No			100	f	146.0780	0.0401	5.065263			
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\*M6061T6R0 500\*

6061-T6 Round Bar .500"

\*\*

DA 12/4/13

Location

Loc Qty

Loc Code

MAT012

146.078

114488

1.997

117379

9.288

119043

134.793

5.06

12

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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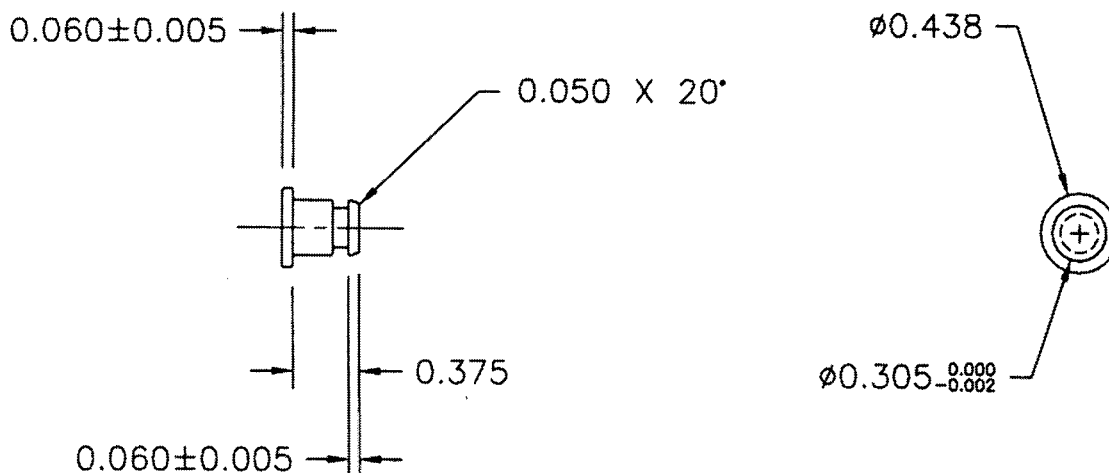


DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2651	REV. B SHEET 1 OF 1
DATE 03.12.19		TITLE PLUG	SCALE 1:1
A	97.03.25	NEW ISSUE	
B	03.12.19	ADD POWDER COAT, MS28775-008	

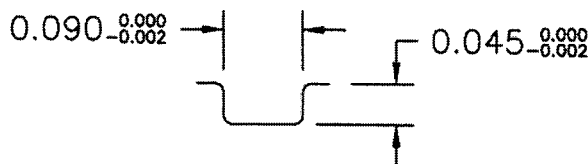
RELEASED

03.12.19

### D2651-1 PLUG:



### GROOVE DETAIL (SCALE 5:1)



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER

NO. 21809/MCJ  
12/03/19

### D2651-1 PLUG

- 1) MATERIAL: 6061-T6 (QQ-A-225/8) OR 1100-0 (QQ-A-225/1)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.010 MAX

### D2651-3 O-RING

- 1) MATERIAL: BUNA N, 70 DUROMETER  
3/16 ID, 5/16 OD, 1/16 WIDTH  
(PARKER 2-008, MS28775-008 OR EQUIVALENT)

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# Dart Aerospace Ltd

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